

Date: Tuesday, 28/11/2006 10:20:09 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : REINFORCEMENT PLATE
Job Number : 29721	
Estimate Number : 11307	
P.O. Number : N/A	Part Number : D34501
This Issue : 28/11/2006 S.O. No. : N/A	Drawing Number : D3450 REV A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : SMALL /MED FAB	Drawing Revision : A
Previous Run : N/A	Material : N/A
Written By : _____	Due Date : 28/11/2006 Qty: 4 Um: Each
Checked & Approved By : _____	
Comment : Est. A 05.08.30 New issue KJ/JLM Est Rev:B Now Waterjet 06-11-28 JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6B0250X04000	6061-T6 Bar .25" x 4.0"
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Comment: Qty.: 0.4812 f(s)/Unit Total : 1.9249 f(s)

6061T6 BAR .250 X 4.0

Material: 6061-T6 Bar (QQ-A-200/8)

(M6061T6B0.250x04.00)

Identify for D3450-1

Batch: M100351 ml 06 11 28

2.0	WATER JET	FLOW WATER JET
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**Comment:** FLOW WATER JET

1-Cut as per Dwg D3450

Dwg Rev: A

Prog Rev: A

2-Deburr if necessary

ml 06 11 28 (4)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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**Comment:** INSPECT PARTS AS THEY COME OFF MACHINE

ml 06 11 28 (4)

4.0	QC8	SECOND CHECK
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**Comment:** SECOND CHECK

ml 06/11/29 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: REINFORCEMENT PLATE

Job Number: 29721

Part Number: D34501

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *WA-25*

OK - 06-11-30 4

6.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

4
06/12/01

Job Completion



u D-01

DART AEROSPACE LTD		Work Order: 29721
Description: Crosstube Assembly Reinforcement plate		Part Number: D3450-1
Inspection Dwg: D3450	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

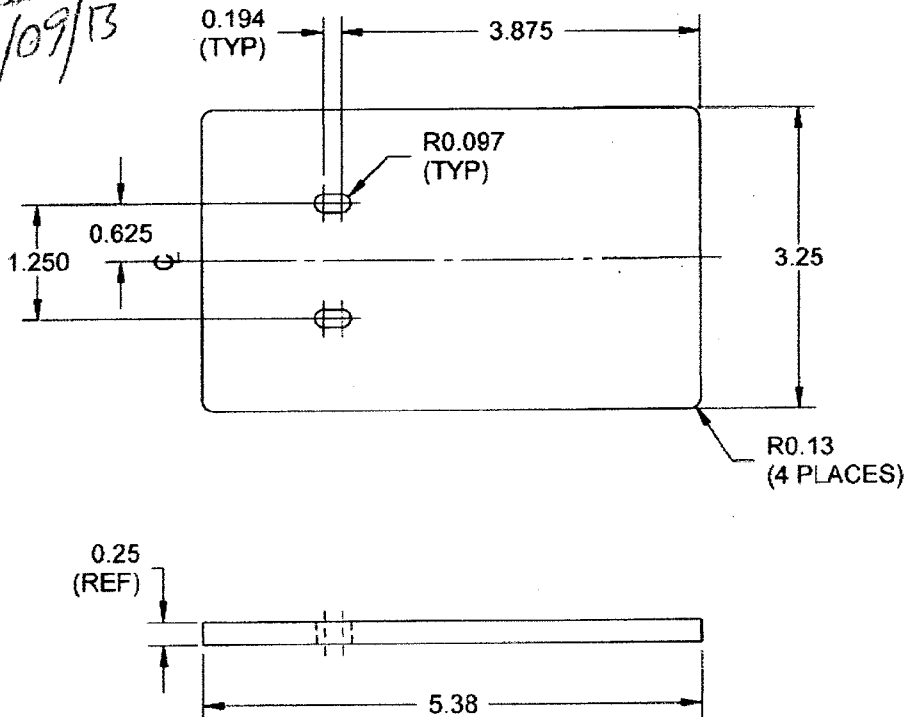
Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
SIDE A	1.250	+/- 0.010	1.250	✓		VERN	
	5.38	+/- 0.030	5.387	✓		VERN	
	0.194	+/- 0.010	0.198	✓		VERN	
	3.25	+/- 0.030	3.258	✓		VERN	
	0.25	+/- 0.030	0.249	✓		VERN	
	0.625	+/- 0.010	0.627	✓		VERN	
	R0.13	+/- 0.030	R0.13	✓		RADIUS GAUGE	
SIDE B							

Measured by: M. M	Audited by: AA	Prototype Approval:	N/A
Date: 06/11/28	Date: 06/11/29	Date:	N/A
Rev	Date	Change	Revised by Approved
A		New Issue	KJ/JLM



DESIGN <i>[Signature]</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3450	REV. A SHEET 1 OF 1
DATE 05.08.25		TITLE BLADE FOLD KIT PLATES	SCALE 1:2
A	05.08.25	NEW ISSUE	

RELEASED
05/09/13



D3450-1 REINFORCEMENT PLATE

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B0.250)
- 2) PART IS SYMMETRICAL ABOUT CENTER LINE.
- 3) TOLERANCES ARE PER QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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